

4 SPLIT

DART AEROSPACE LTD	Work Order:	20382 <i>fb</i>
Description: Bearpaw Kit (48" x 19") 205/430	Part Number:	K10015
Dwg: D2521 Rev. H	Qty:	5 10 Kits
Ref: K10015 Rev. A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																									
1	DC	Issue Traveler Note: (1) K10015 Kit consists of Qty (2) D2521 Dwg not required	HD	04.02.16	10																																									
2	DC	Photocopy bluefile: K10015 D205-564-011 D430-688-011 and create labels per PPP K10015 CHG002 WK 8 (Bag Bluefiles separately)	HD	04.02.23	10																																									
3	GA	Cut 2 blanks per (1) K10015 Kit Cut blank: 19.50" x 48.00" x 1.00" thick f.030 -000 Material: Black UHMW "1" (MUHMWB10) Batch: M14416	P.D. R.L.	04/03/16	10																																									
4	MV	Inspect material for defects or damage prior to machining	mf	04/03/30	10																																									
5	MV	Machine as per Folio FA222 and Dwg D2521	mf	04/03/31	10																																									
6	QC2	Inspect parts as they come off the CNC machine	mf	04/03/31	10																																									
7	MV	Deburr	mf	04/03/31	10																																									
8	MV	Form as per Dwg D2521 using bending Jig DT8328	mf	04/03/31	10																																									
9	QC8 & 5	Second inspection	mf	04/03/31	10																																									
10	KP	Pick: Packing Kit (Note: D2521 is on the BOM as material from step 3) <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>8</td><td>D2182B055</td><td>Rubber Cushion</td><td>B20434 / B19540</td></tr><tr><td>16</td><td>D2274</td><td>Radius Block</td><td>B19922 / B19599</td></tr><tr><td>2</td><td>D2521</td><td>Bearpaw</td><td>B20382</td></tr><tr><td>16</td><td>D2529</td><td>Washer</td><td>B19486</td></tr><tr><td>8</td><td>D2947</td><td>Clamp</td><td>B19106</td></tr><tr><td>16</td><td>AN4-15A</td><td>Bolt</td><td>M14115</td></tr><tr><td>16</td><td>AN960JD416</td><td>Washer</td><td>M14312</td></tr><tr><td>16</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M13276</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td><td>✓</td></tr></table>	Qty	Part Number	Description	Batch	8	D2182B055	Rubber Cushion	B20434 / B19540	16	D2274	Radius Block	B19922 / B19599	2	D2521	Bearpaw	B20382	16	D2529	Washer	B19486	8	D2947	Clamp	B19106	16	AN4-15A	Bolt	M14115	16	AN960JD416	Washer	M14312	16	MS21042L4	Nut (or -4)	M13276	1	Paperwork package from Step 2			✓	CP	04/03/30	5
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1	Paperwork package from Step 2			✓																																										
11	QC4	Inspect Kit for 100% Completeness on the W/O	CP	04-03-30	5																																									
12	PK	Identify and pack for shipping as per PPP K10015 Rev.C WCF	WCF	04/04/01	5																																									
13	AC	Cost / part 306.97 5 hr	502	04-04-05	5																																									
14	DC	Close W/O 366.42 Inspect Level 21	HD	04.04.07	5																																									

Rev	Date	Change	Revised By	Approved
A	01.10.16	K10015 created for Bearpaw Kit (MPP 2164)	SM	
B	03.05.26	Reformat; Incorporated D2521	KJ/RF <i>RF</i>	<i>A</i>

PM 04-11-6

RELEASED
03.07.01 *RF*

KROSPACE LTD		Work Order:	20382
Description: Bearpaw		Part Number:	D2521
Inspection Dwg: D2521	Rev: H	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	1.000	+/-0.030	1.003	✓		Vern	
B	5.600	+/-0.030	5.595	✓		Vern	
C	11.500	+/-0.030	11.500	✓		M-Tape	
D	10.250	+/-0.010	10.250	✓		M-Tape	
E	13.250	+/-0.010	13.250	✓		M-Tape	
F	8.500	+/-0.010	8.500	✓		M-Tape	
G	22.125	+/-0.030	22.125	✓		M-Tape	
H	8.75	+/-0.010	8.750	✓		Vern	
I	44.500	+/-0.030	44.500	✓		M-Tape	
J	6.688	+/-0.030	6.681	✓		Vern	
K	5.625	+/-0.030	5.622	✓		Vern	
L	7.000	+/-0.030	7.000	✓		M-Tape	
M	5.000	+/-0.010	5.004	✓		Vern	
N	4.000	+/-0.030	3.998	✓		Vern	
O	6.625	+/-0.030	6.618	✓		Vern	
P	19.000	+/-0.030	19.000	✓		Vern	
Q	0.31 x 45°	+/-0.030	0.290x45°	✓		Vern	
R	0.19 x 45°	+/-0.030	0.172x45°	✓		Vern	
S	0.50 x 45°	+/-0.030	0.475x45°	✓		Vern	
T	0.38 x 45°	+/-0.030	0.355x45°	✓		Vern	
U	0.063 x 45°	+0.030/-0.010	0.043x45°	✓		Vern	
V	Ø0.260	+0.005/-0.000	Ø0.260	✓		Vern	
W	Ø0.93	+/-0.030	Ø0.930	✓		Vern	
X	0.30	+0.030/-0.010	0.302	✓		Vern	
Y	0.375	+/-0.010	0.373	✓		Vern	
Z	0.750	+/-0.030	0.746	✓		Vern	
AA	0.250	+/-0.010	0.245	✓		Vern	
AB	4.000	+/-0.030	3.998	✓		Vern	
AC	6.625	+/-0.030	6.614	✓		Vern	
AD	0.950	+0.030/-0.010	0.948	✓		Vern	
AE	0.375	+/-0.010	0.380	✓		Vern	
AF	3.399	+/-0.030	3.385	✓		Vern	
AG	6.625	+/-0.030	6.614	✓		Vern	

Measured by: <i>ML</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 04/03/31	Date: 04/03/31	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	P/O K10015	KJ/RF

RELEASED

24.01.15



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 16, 2004
01:36 pm

Work Order No : 0020382
Project Name : *K10015
Project For : WK409
Work Order Type : Main
Main WO Number :
House Part Number : *K10015
Description : Bearpaw Kit
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 02-16-04
Est Finish Date : 02-27-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00